Work Ord Friday, May 16						Page 1					
Item ID: Revision ID: Item Name:	D3560-04 Arm Weldn	_		Accept	*N900	04 0	100	* S	Setup Sta Sto	17	S1* S2*
Start Date: Required Date Reference:	5/15/14 : 5/15/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					
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Sequence ID/ Work Center I Draw Nbr		Operation Description evision Nbr		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Work Order ID 119472

119472

Page 2

Friday, May 16, 2014 12:43:54 PM Accept *N900040100* Item ID: D3560-041 Setup Start **Revision ID:** Stop Arm Weldment **Item Name:** *4* Start Qty: 4.00 **Start Date:** 5/15/14 **Cust Item ID:** Required Date: 5/15/14 **Req'd Qty:** 4.00 *4* **Customer:** Reference: Start Run Date: ____ **Tooling: Process Plan:** Date: **Approvals:** Stop Date: SPC (Y/N): Date: Sequence ID/ **Operation** Tool ID Tool # Plan Accept Reject Reject Set Up/ Insp. **Work Center ID** Code Qty Qty Number Stamp **Description Run Hours** 140 0.00 Large Fab *140* (4) 14-06-05 Large Fab 0.00 Memo Large Fab 1-Weld assembly as per dwg D3560 STEP: 1- clean material (buff bracket and bottom of arm with blue pad) 2- set up bracket and arm on jig 3- preheat bracket and arm with torch 4- clean before welding with brush 5- set up machine to 135 amps 6- weld across bottom and top ends 7- reheat with torch (65 deg C) 8- on one side weld from bottom to top half way 9- same for other side (half way) 10- from half way point weld the rest of the first side (ease off pedal near 11- same for remaining side (ease off pedal near end) 150 QC5- Inspect part completeness to step on W/O 0.00 *150* OC 0.00 Memo Quality Control

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
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Friday, May 16	6, 2014 12:43	:54 PM									
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Sequence ID/ Work Center I 160 *160* QC Quality Control	ID	Operation Description QC9- Inspect visual per Memo	QSI004- Fusion Welds	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* HandFinish Hand Finishing		Chemical Conversion C Memo	oat per QSI005 4.1	0.00				4	_ %) 146	<u> </u>
180 *1 RO* QC Quality Control		QC7-Inspect Chemical Memo	Conversion Coat	0.00				4	\$		DAS 19 9-69

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Friday, May 16, 2014 12:43:54 PM Accept Item ID: D3560-041 *N900040100* Setup Start **Revision ID:** Stop Arm Weldment **Item Name:** *4* **Start Date:** 5/15/14 Start Qty: 4.00 **Cust Item ID:** Required Date: 5/15/14 Req'd Qty: 4.00 *4* **Customer:** Reference: Run Start **Tooling:** Date: **Approvals:** Process Plan: Date: Stop QC: Date: SPC (Y/N): Date: Tool ID Sequence ID/ Operation Set Up/ Tool # Plan Accept Reject Reject Insp. **Work Center ID Run Hours** Code Qty Qty Number Stamp Description 190 0.00 Small Fab *190* Small Fab 0.00 Memo 1-Press bushing in D3560 arm per dwg D3562 Small Fab 200 QC5- Inspect part completeness to step on W/O *200* OC Memo Quality Control Identify as per dwg & Stock Location: WADD 0.00 210 *210* Packaging 0.00 Memo *** STOCK IN STEP CELL*** Packaging

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	ding Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence General Bend BoM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set	ion Incomplete/Ur tions Incomplete/U gned/off center eled d		Outside Dim Over/Under Part Incorred Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
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Work Order ID 119472

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Friday, May 1	6, 2014 12:4	13:54 PM			141/							
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Page 1

Friday, May 16, 2014 12:43:58 PM

Work Order ID: 119472

119472

Parent Item:

D3560-041

D3560-041

Parent Item Name: Arm Weldment

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A IPP rev B

IPP Rev:C

New Issue 07.05.24

ECN 987 07.10.09 ECN1048 07-12-18

EC

EC verified by: DD DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808		Manufactured	No				Each	88.0000		4		/	DAS
D2808									**		4/00/	/16	36 9-89
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